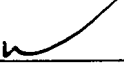


Date: Monday, 11/13/2006 7:50:37 AM  
User: Chantal Lavoie









## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: AFT STRUT ASSEMBLY
<b>Job Number</b>	: 29433		
<b>Estimate Number</b>	: 11286		
<b>P.O. Number</b>	: N/A	<b>Part Number</b>	: D3437041
<b>This Issue</b>	: 11/13/2006	<b>Drawing Number</b>	: D3437 REV B
<b>Prsht Rev.</b>	: NC	<b>Project Number</b>	: N/A
<b>First Issue</b>	: N/A	<b>Drawing Revision</b>	: B
<b>Previous Run</b>	: 29414	<b>Material</b>	: N/A
<b>Written By</b>	: 	<b>Due Date</b>	: 11/20/2006
<b>Checked &amp; Approved By</b>	: _____	<b>Qty:</b>	1
<b>Comment</b>	: Est. A 05.05.20 New Issue KJ/JLM	<b>Um:</b>	Each

### Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D34371	Foot
		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Foot Pick: Qty Part Number Description Batch 1 D3437-1 Foot B27652		
2.0	D34373	Clip
		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Clip Pick: Qty Part Number Description Batch 1 D3437-3 Clip B23408B		
3.0	D343711	Eye Bolt
		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Eye Bolt Pick: Qty Part Number Description Batch 1 D3437-11 Eye Bolt B27833		
4.0	MS210435	Nut
		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Self Locking Nuts Pick: Qty Part Number Description Batch 1 MS21043-5 Self Locking Nut B101418		

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ED Date: 06/11/13  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 11/13/2006 7:50:37 AM  
User: Chantal Lavoie

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT STRUT ASSEMBLY

Job Number: 29433

Part Number: D3437041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3437

Dwg Rev: B

SB 06/11/13

①

6.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

06/11/13 ①

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

06/11/13 ①

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/11/13 ①

Job Completion



C2del11113

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

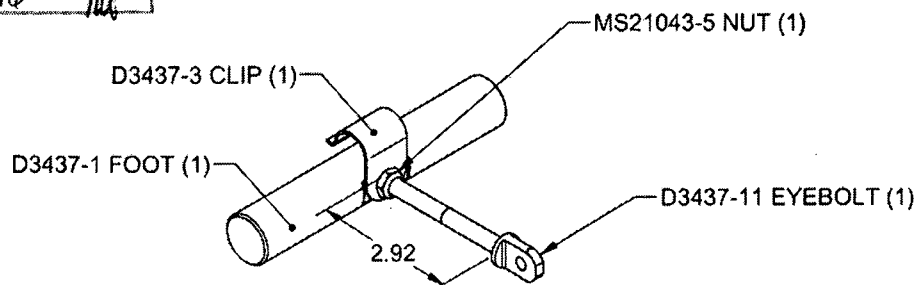
**NOTE:** Date & initial all entries



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3437</b>	REV. B SHEET 1 OF 4
DATE <b>05.08.11</b>		TITLE <b>AFT STRUT ASSEMBLY</b>	SCALE 1:2
A	05.04.29	NEW ISSUE	
B	05.08.11	UPDATE D3437-5/-9/-11 DIMENSIONS	

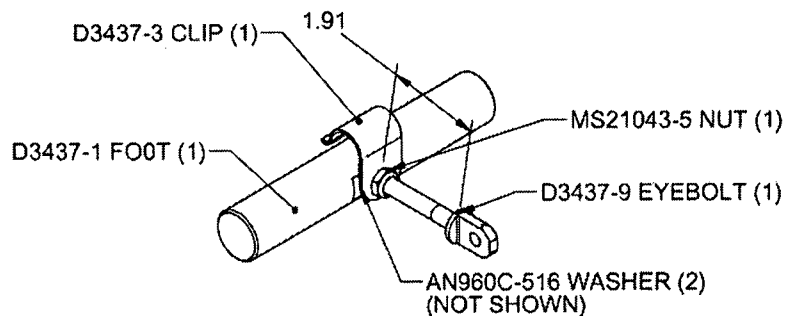
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05.08.16 *[Signature]*

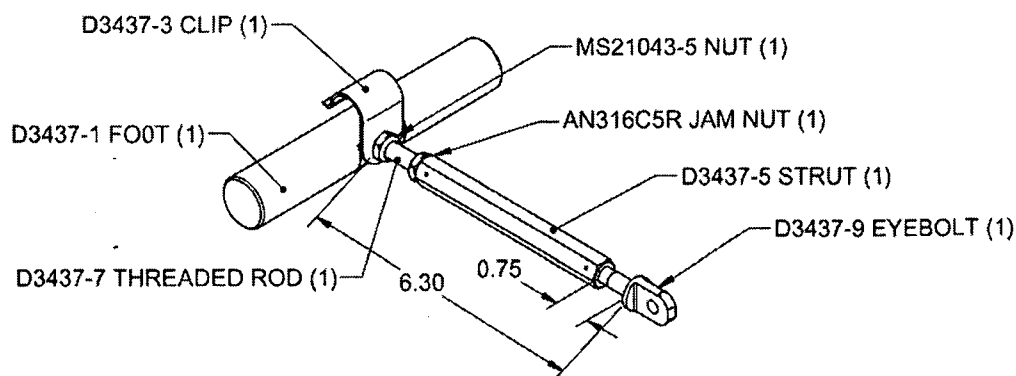


**D3437-041 AFT STRUT ASSEMBLY**

REFERENCE ONLY



**D3437-043 AFT STRUT ASSEMBLY**



**D3437-045 AFT STRUT ASSEMBLY**

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

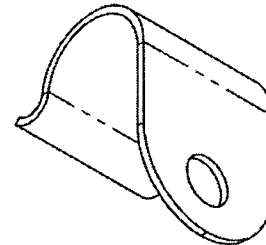
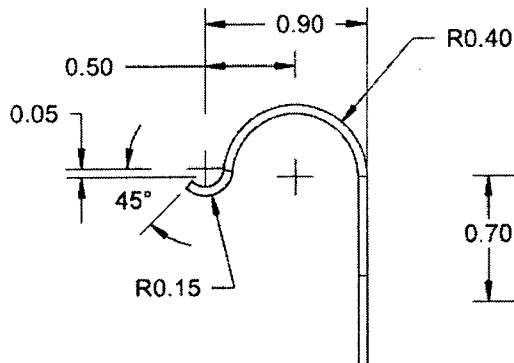
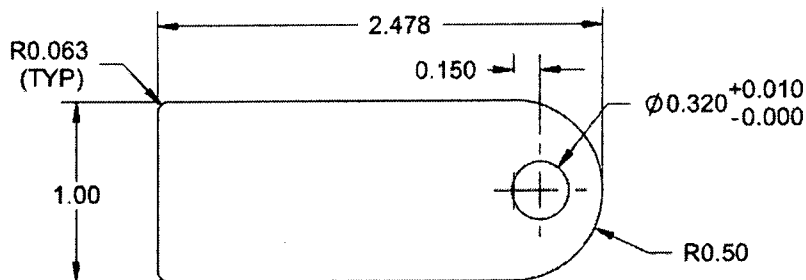
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

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DATE <b>05.08.11</b>	TITLE <b>AFT STRUT ASSEMBLY</b>		SCALE 1:2

**RELEASED**05.08.11 *[Signature]***REFERENCE ONLY****D3437-3 CLIP**  
**SCALE 1:1****D3437-3**  
**FLAT PATTERN****D3437-3 CLIP:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.050 THICK (REF DART SPEC M304S18GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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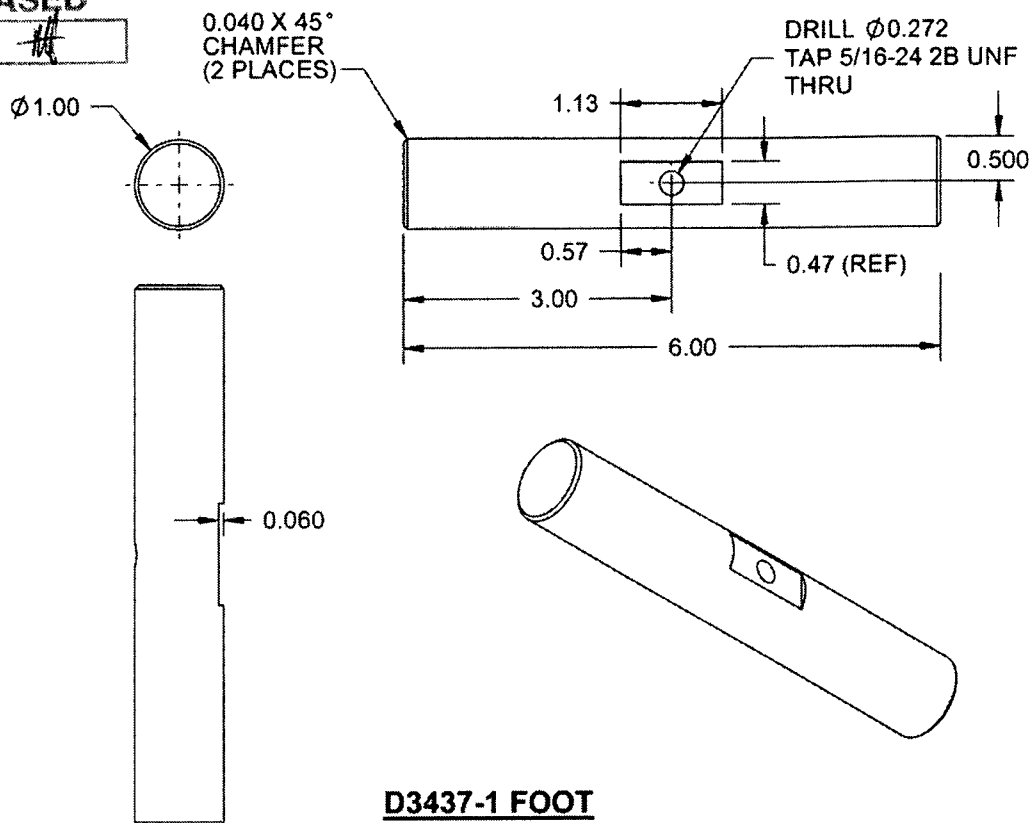
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DATE <b>05.08.11</b>		TITLE <b>AFT STRUT ASSEMBLY</b>	SCALE 1:2

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05-08-16 *[Signature]*

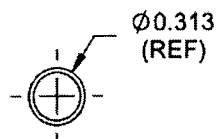
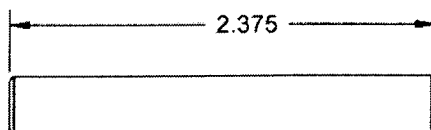


REFERENCE ONLY

### D3437-1 FOOT

#### D3437-1 FOOT:

- 1) MATERIAL: 6061-T6 (QQ-A-225/8 OR QQ-A-200/8) ALUMINUM ROUND BAR  
(REF. DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010



### D3437-7 THREADED ROD

#### D3437-7 THREADED ROD:

- 1) POSSIBLE SUPPLIER: HASKINS-SPAENAUR P/N 870-832 18-8 5/16-24 SS THREADED ROD
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

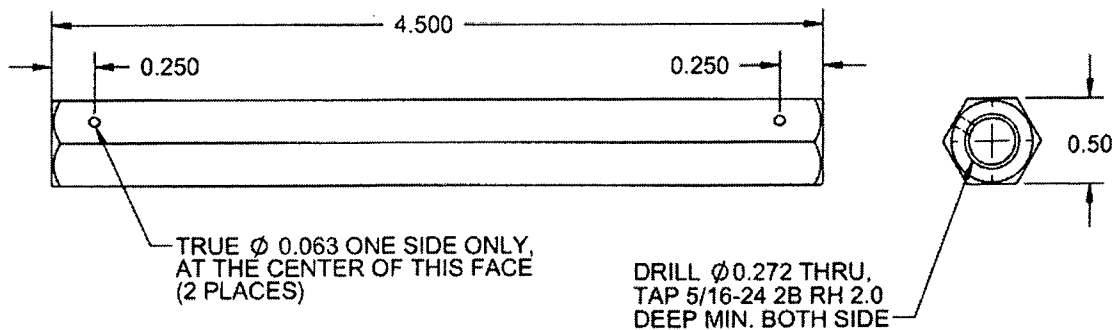
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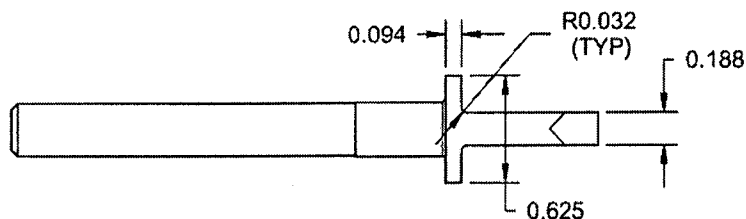
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DATE <b>05.08.11</b>		TITLE <b>AFT STRUT ASSEMBLY</b>	SCALE 1:2



**D3437-5 STRUT:**

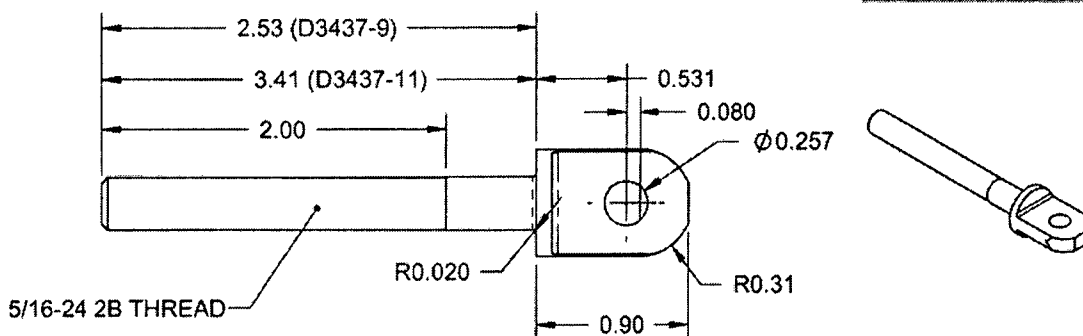
- 1) MATERIAL: AISI 303 STAINLESS HEX BAR (DART REF. SPEC M303H0.500)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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**D3437-9/-11 EYEBOLT:**

- 1) MATERIAL: AISI 303 STAINLESS ROUND BAR (DART REF. SPEC M303R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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